

SPLIT

Dart Aerospace Ltd.

31

Date: Tuesday, 7/17/2007 1:59:08 PM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HELI-ACCESS STEP RH (FOLDING)
Job Number	33577	Part Number	D412630034
Estimate Number	12568	Drawing Number	IIN UNDER REVIEW
P.O. Number	N/A	Project Number	N/A
This Issue	7/17/2007	Type	LARGE FAB ASSY
Prsht Rev.	NC	Drawing Revision	K
First Issue	N/A	Material	N/A
Previous Run	32716	Due Date	8/3/2007
Written By		Qty:	
Checked & Approved By	<u>7/17/07</u>	Um:	Each
Comment	Est. Rev.A New Issue 06-11-08 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	DC	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-034 CHG002		
2.0	D2012107	Clevis 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Clevis Pick: Qty Part Number Description Batch 1 D2012-107 Clevis B 32051 1X B 33585 10		
3.0	D2803042	Bracket Assembly 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2803-042 Bracket Assembly RH B 27283 1X B 28392 5X		
4.0	D2804042	Bracket Assembly 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2804-042 Bracket Assembly RH B 26252 1X B 29409 2X		

Date: Tuesday, 7/1/2007 1:59:09 PM  
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## Process Sheet

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2807 Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

*B33274*

*PC*

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

*B335921X*

*B3077611X*

*PC*

7.0 D3562042 STEP ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description	Batch
1	D3562-042	Step Weldment RH	<i>33590</i>

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	<i>B284086X</i>

*B3278318X*

*PC*

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	<i>M1011F9</i>

*PC*

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN8C16 Bolt



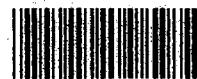
Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN8C16	Bolt	M102736

11.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	AN310C8	Nut	M104678

12.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description	Batch
2	MS24665-302	Cotter Pin (or AN380C3-4)	M16941

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	NAS1515H3	Washer	M105764

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H5L	Washer	M104866 FX

M105728 16X

16X

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Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M104811 9X

M102067 15X

*EE*

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M105728

*EE*

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

*EE*

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M104922

COAT exposed HARDWARE WITH LPS PROCYON.

*SB 07/10/12*

A/R LPS-PROCYON BATCH: M17845

19.0 QC5 INSPECT WORK TO CURRENT STEP



*10/10/12 D*



Comment: INSPECT WORK TO CURRENT STEP

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	<u>B32772</u>

22.0 D28063 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	<u>B29847</u>

23.0 D28105 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	<u>B32775</u>

24.0 D33961 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	<u>B29996</u>

25.0 AN4C6A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	<u>M105426</u>



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	NAS1515H5	Washer
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M105792

32.0	MS210434	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	M1057930

33.0	MS210435	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	M1057930

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location: A

PPP Rev: A

36.0	QC21	FINAL INSPECTION/W/O RELEASE
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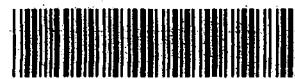


Comment: FINAL INSPECTION/W/O RELEASE

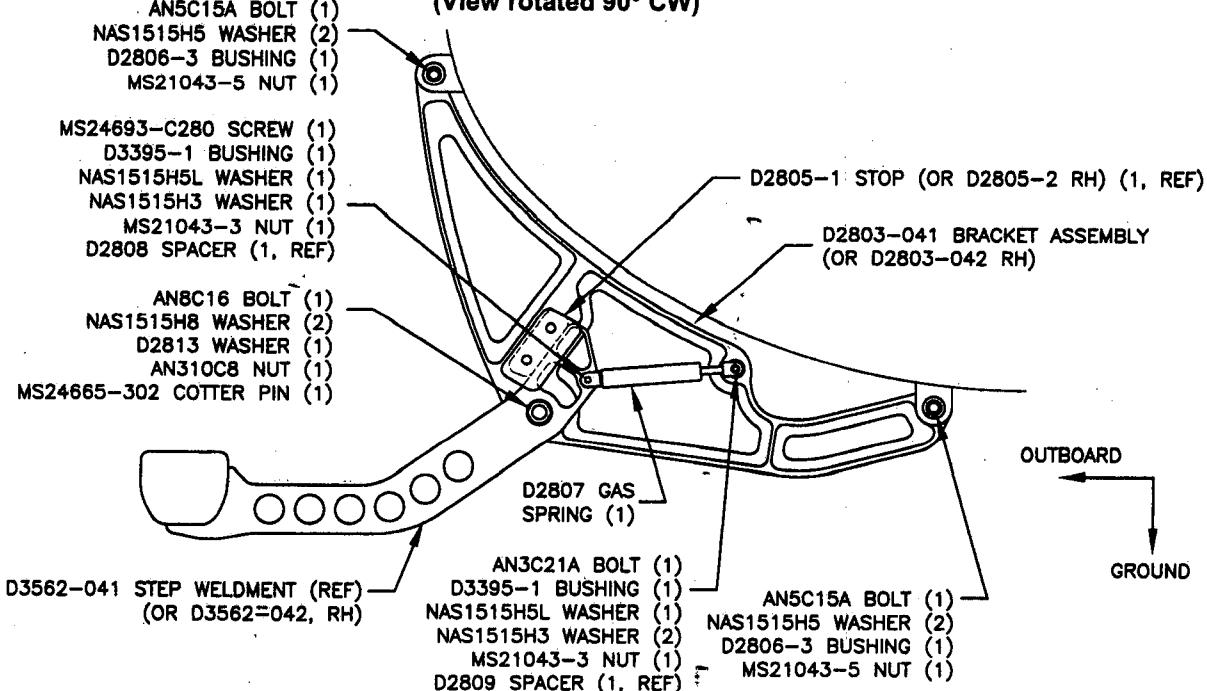
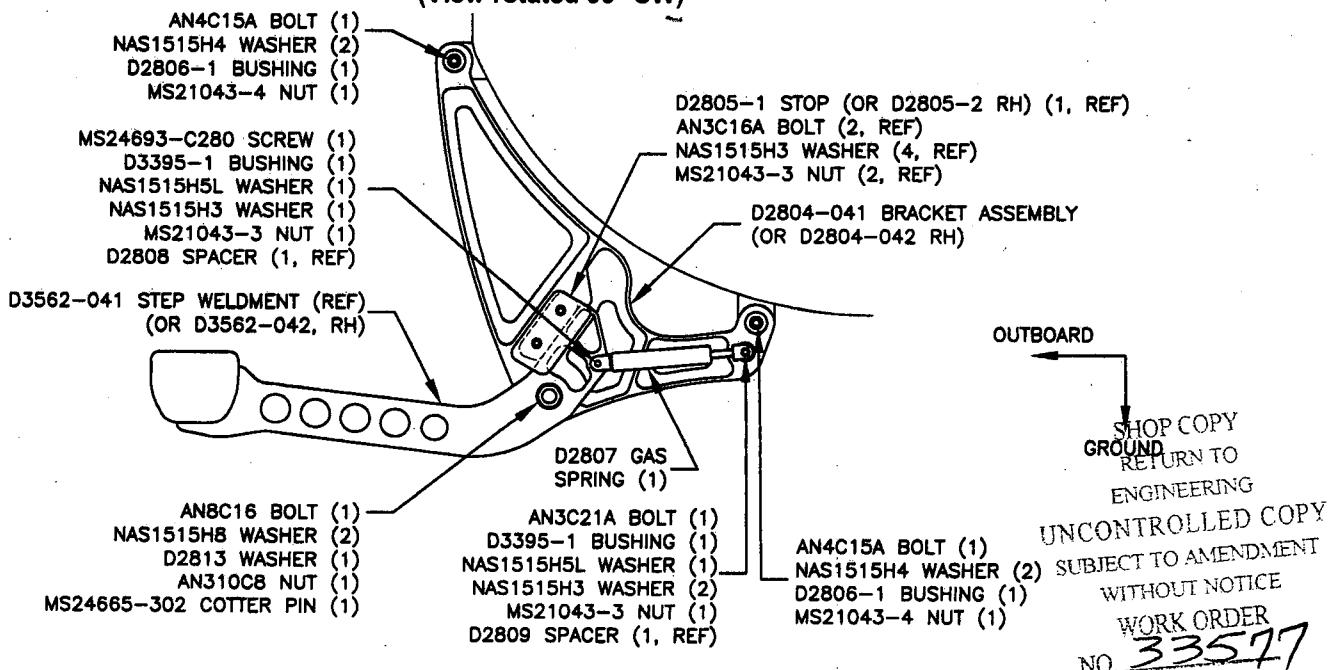


1 07/16/12

Job Completion



C 07/11/12

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**

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Revision: **K**  
Date: 06.10.05